

Date: Monday, 10/11/2008 3:34:19 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LH ACTUATOR ASSEMBLY
Job Number : 43286	
Estimate Number : 12761	
P.O. Number :	Part Number : 41232 200 001 001
This Issue : 10/11/2008 S.O. No. :	Drawing Number : 41232-200-001 REV IR
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SMALL /MED FAB	Drawing Revision : IR
Previous Run : 42218	Material :
Written By :	Due Date : 28/11/2008 Qty: 2 Um: Each
Checked & Approved By : <u>JLD 08.11.11</u>	
Comment : Est Rev:A New Issue 07-02-28 JLM	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

MS208224

elbow



91129



50

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

elbow

Batch: M110239

M110239

2.0

AN8424D

Elbow



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Elbow

Batch: M110139

10 8/14/18

3.0

41232 200 007 001

Brass Cylinder Assembly



2x

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Brass Cylinder Assembly

Batch: B42266

91129

54

4.0

MS1699623

cap screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

cap screw

Batch: M103934

JS 08/12/02 (2)

5.0

AN3154R

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M17566

JS 08/12/02 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LH ACTUATOR ASSEMBLY

Job Number: 43286

Part Number: 41232 200 001 001

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	AN960JD416	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

Batch:

M109249

SS 08/12/02 (2)

7.0	AN960JD10	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

Batch:

M109061

SS 08/12/02 (2)

8.0	MS21042L3	Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch:

M109031

SS 08/12/02 (2)

9.0	AN322A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch:

M100043

SS 08/12/02 (2)

10.0	41232 200 005 003	Spacer (Step Actuator)
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Spacer (Step Actuator)

Batch:

43732

SS 08/12/02 (2)

11.0	41232 200 002 005	pivot arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

pivot arm

Batch:

B43305

911629 2x

12.0	41232 200 002 003	latch
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

latch

Batch:

B43304

2x 12912/09 911629 5x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 43286

Part Number: 41232 200 001 001

Job Number:



Seq. #: Machine Or Operation: Description :

13.0 41232 200 002 001 tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

tube

Batch: 43303

SS 08/12/02 (x3)

14.0 41232 200 008 001 Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Decal

Batch: 104079 31780

SS 08/12/02 (x2)

15.0 S 1455 spring-step actuator (replaces 71459)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

spring-step actuator (replaces 71459)

BATCH: 104079

SS 08/12/02 (x2)

16.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg 41232-200-001

2-Torque as per Dwg 41232-200-001

FF 09/01/29

(2)

17.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SS 09/01/29 (x2) (40)

18.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPA 43267

09/01/29 (3)

19.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/02

Job Completion



MF 09-01-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

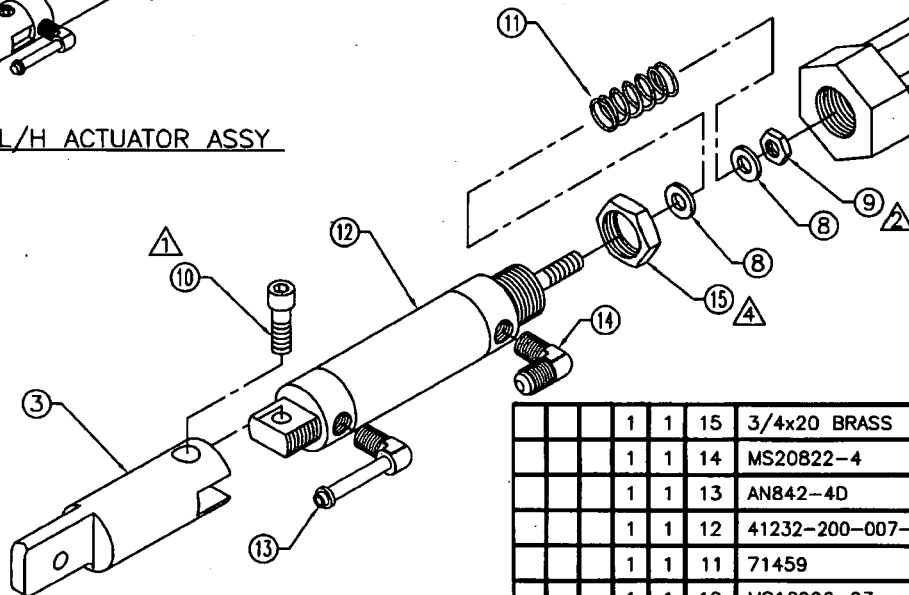
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

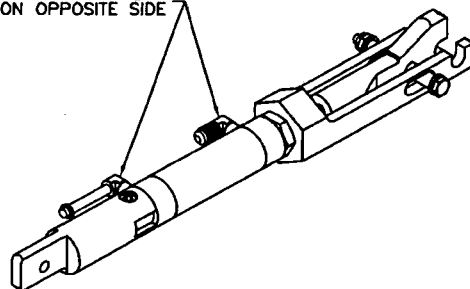
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries





-001 L/H ACTUATOR ASSY



INSTALL ITEM #12
ON OPPOSITE SIDE



-002 R/H ACTUATOR ASSY

-  TORQUE 80-100 IN.-LB.
 TORQUE 20-25 IN.-LB.
 TORQUE 50-75 IN.-LB.
 TORQUE 50-75 IN.-LB.

NOTES:

UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43284
TOR ASSY

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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